Work Orde October-23-13		8590		*108	3590*				<u> </u>			Page 1
Item ID: Revision ID:	D4035-041		1	Accept	*N900	040	100)*	Setup		*N	S1*
Item Name:	Lid Rib Assem	nbly, Fwd (350 Basket)								Stop	*N	S2*
Start Date:	10/23/13	Start Qty: 2.00	*2*		Cust Item	ID:						
Required Date: Reference:	10/30/13	Req'd Qty: 2.00	*2*		Customer:		•					
Approvals:	Process Pla	in: <u>ML</u> 5	Date: 13-10-23	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:			SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D4035	A											
100		Weld per dwg A/R S.S	rod Batch 6/23823	0.00						•		
100								(Z)	CC	13-	10-2	4
Large Fab		Memo		0.00								
Large Fab		2- Drill hole 3- remove i	035-1 as per dwg D4035 es as per dwg D4035 using D dentification marks and debu	ırr								
		4- weid bu	shing in rib as per dwg D403	3								
* *110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00					2	Ao		
110								2x	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	13	12-1	10-25
QC ·		Memo		0.00					— ``- 9	-89-	10.7	.0
Quality Control												
•												
120		QC5- Inspect part comp	leteness to step on W/O	0.00					DA	5		
1 <i>2</i> 0				0.00				ax	_\ 43 _\&&		13 -	10·25
QC		Memo		0.00						-		

Quality Control

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Work Orde	er:				•	DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
Part N	- No					Rework Scrap Use-as-is Work Order Update	The	۱ erm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root	Т				Descri	ption of work order update	Initia	1	Action		Sign &		T	
Cause		Date	Step	Qty		or Non-conformance Chief Eng Description					Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						or Non-comormance Chief Eng Description								
						F	AULT CA	TEC	GORY					
Landi		ear Bending				General Bend	Gra	in			Ovalized		_	Pressure/Forced
		-	ot Conce	ntric to	o/s	BOM/Route	Hard		re		Over/Under	tolerance		Temperature/Cure
	$\boldsymbol{\vdash}$	Centre Not Concentric to O/S Cracks				Broken/Damaged	├ ─┤		on Incomplete		Part Incorred	- -	_	Weld
	Crushed/Crimped					Burrs	Insti	ructi	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs					Contamination	Mai	inte	nance		Part Moved	_		
	Heat Treat					Countersink	Misl	labe	led	L	Positioned V	/rong		
	Inspection Strip in Tube					Cut Too Short	Mist	read	1		Power Loss/	Surge		Other
		Ripples in Bend				Drill Holes	Offs	et						

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde	er ID 108590 7:59:13 AM		*108	3590*							Page 2
Item ID: Revision ID: Item Name:	D4035-041 Lid Rib Assembly, Fwd (350 Basket)	A	Accept	*N900	040	100) * s	_		NS NS	•
Start Date: Required Date: Reference:	10/23/13 Start Qty: 2.00 10/30/13 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:						
Approvals:	Process Plan:	Date:	Tooling: SPC (Y/N):		nte:		F		art 4	'NR 'NR	1* 2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging	Operation Description Identify as per dwg & Sto	ck Location: WATOM	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty			isp. tamp
140 * 140 *	QC21- Final Inspection - Memo	Work Order Release	0.00				Ri 	m 13	3/10/2	q. /	, A

Quality Control

									DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	CONFOR	MANCE / U		QA Closed:	Date:	
Work Order					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	D	1 1 1			Rework Scrap Use-as-is Work Order Update		Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		Description of work order update Initial Action Step Qty or Non-conformance Chief Eng Description						Action	Sign &		
Cause	Date	Step	Qty	0	r Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector
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Landing	Landing Gear General										

Pressure/Forced Grain Ovalized Bending Bend BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Maintenance Part Moved Cuffs Contamination Mislabeled Positioned Wrong Heat Treat Countersink Inspection Strip in Tube Misread Power Loss/Surge Other Cut Too Short Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Outside Dimensions Wave/Twist in Tube

October-23-13 7:59:17 AM

Work Order ID: 108590

108590

Parent Item:

D4035-041

D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 10/23/13

Required Date: 10/30/13

Start Qty: 2.00

Required Oty: 2.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC

IPP Rev:B as

per dwg revA 10.03.15 verified by:EC

IPP Rev:C 13.03.14 AS

PER DWG REV.pb1 DD VERF:JLM IPP Rev:D 13.06.24 AS PER DWG

REV.pb2 DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	88.0000	1	2			
D2327-3									**	(1/13-	10-2	24

Spacer Bushing

Location	Lo	oc Qtv	Loc Code		
WA004		88		-	
100523		41			
101800		5			<u>(Zx)</u>
103679		40			
81144		2			
	100	f	735.4940	1.75	4 ^

M304TS0.750W.049

Purchased

No

Loc Code

CC 13-10-224

M304TS0 750W 049*

Location Loc Qty WA006 735.4940331 M126039 89.9999331 391.3285 M126900 254.1656

304 SQ Tube .75x.75x.049W

											DQA:	Date	:
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Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is]	Therm	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۱o					Work Order Update]		Large Fab	Composite	j	Supplier	
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/L	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	led		Positioned \	Wrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	'Surge	Other
	П	Ripples in	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

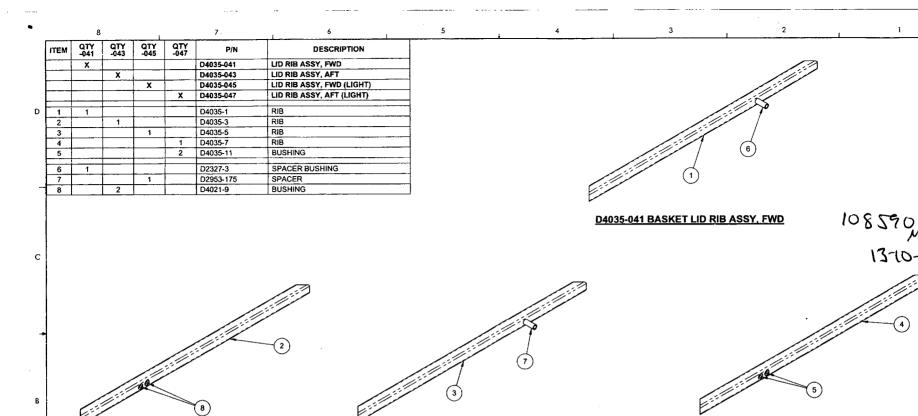
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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D4035-043 BASKET LID RIB ASSY, AFT

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)



Α	NEW IS	SUE		JPH	10.03.04
REV.			DESCRIPTION	BY	DATE
DESIG	N	AJS	DART AEROSI	ACEL	ľD
DRAW	N	JP#H	HAWKESBURY, ONTA	RIO, CANA	DA
CHECK	ŒD	B	DRAWING NO.		REV. A
MFG. A	PPR.	Z	D4035	_	SHEET 1 OF 5
APPRO	VED	W	TITLE		SCALE
DE API	PR.	-#	BASKET LID RIB AS	SSY	NTS
DATE	10.0	3.04	COPYRIGHT © 2010 BY DAR THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND SUP- MOT TO BE USED FOR ANY PURPOSE OR COMMON THE WRITTEN AT MAINS ON THE OWN THE	PLEO ON THE EXPRESS UNICATED TO ANY OTH	CONDITION THAT IT IS

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
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	Cracks			<u> </u>	Broken/Damaged	\vdash		ion Incomplete	_	Part Incorred		Weld	
	Crushed/	'Crimped		-	Burrs	\vdash		tions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs			_	Contamination	\vdash	Mainte			Part Moved			
	Heat Treat				Countersink	\vdash	Mislabe		<u> </u>	Positioned V	_	-	
	Inspection Strip in Tube				Cut Too Short	\vdash	Misread	t	<u>L</u>	Power Loss/	Surge	Other	
	Ripples in			<u> </u>	Drill Holes	_	Offset						
	Torque V			n	Drawing	\vdash		Calibration					
	Turning Sequence Finish					1 1	Out of 9	Seguencé					

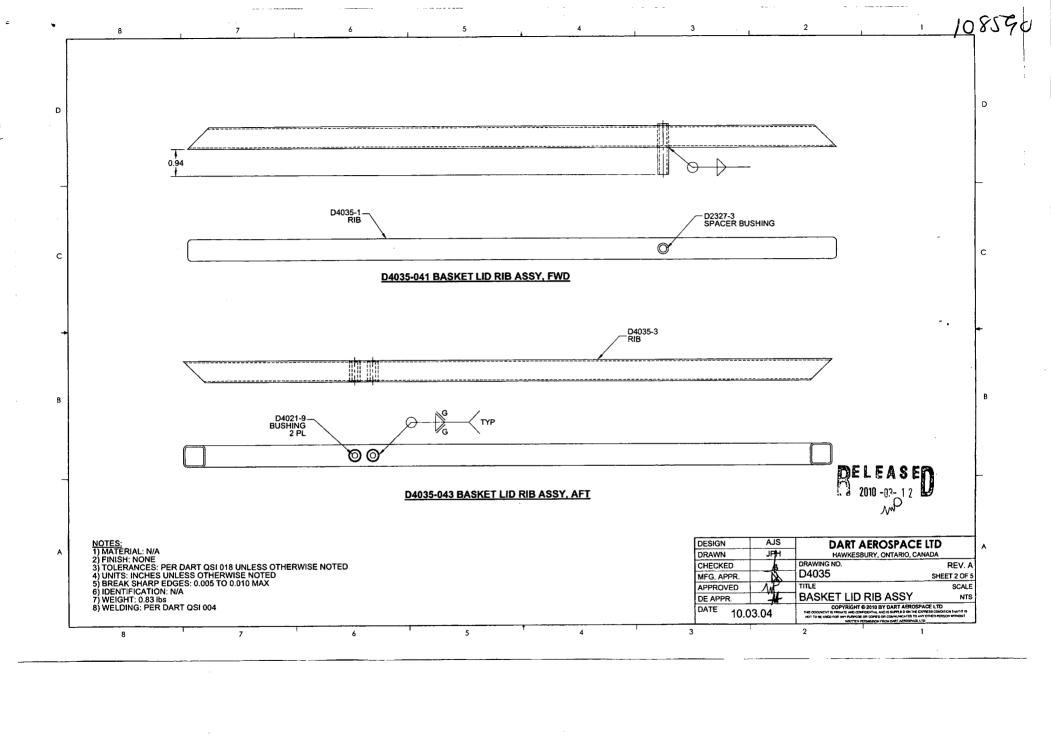
Outside Dimensions

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Wave/Twist in Tube

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NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
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	Cuffs					Contamination	L	Mainte	-		Part Moved			
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	-	Inspectio		Tube		Cut Too Short		Misread	<u> </u>		Power Loss/	Surge		Other
	Ripples in Bend				<u> </u>	Drill Holes		Offset						
		Torque V	Vaves in E	Extrusior	١	Drawing	L	Out of C	Calibration					

Out of Sequence

Outside Dimensions

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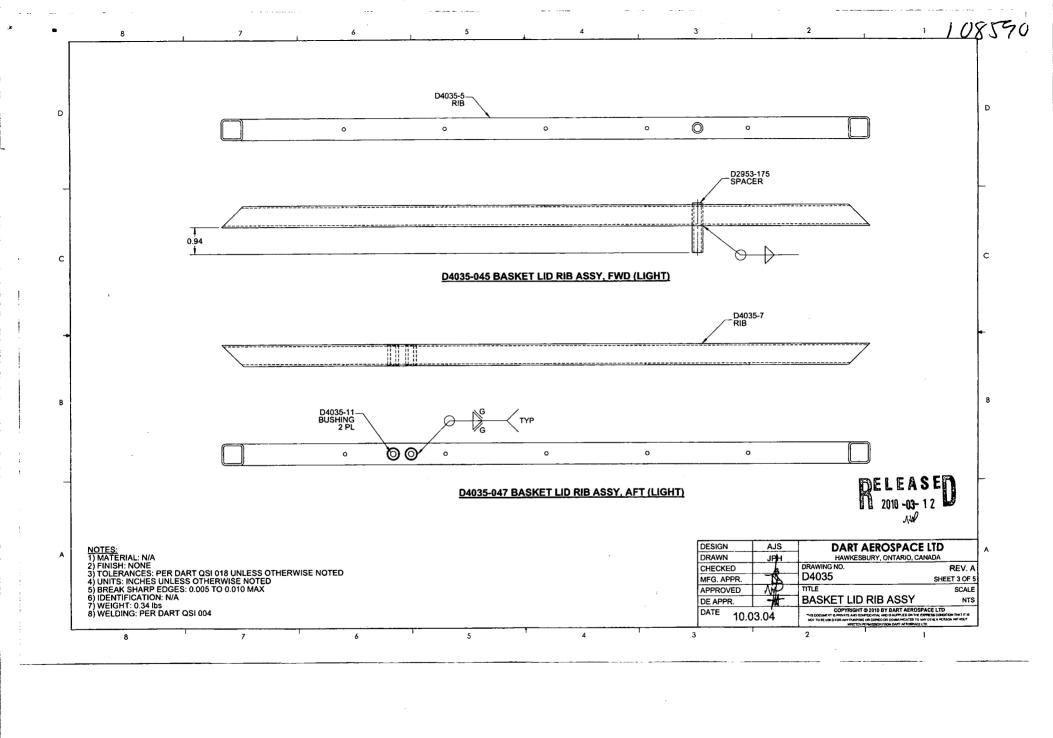
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Turning Sequence

Wave/Twist in Tube

Finish

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NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
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Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
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Out of Sequence

Outside Dimensions

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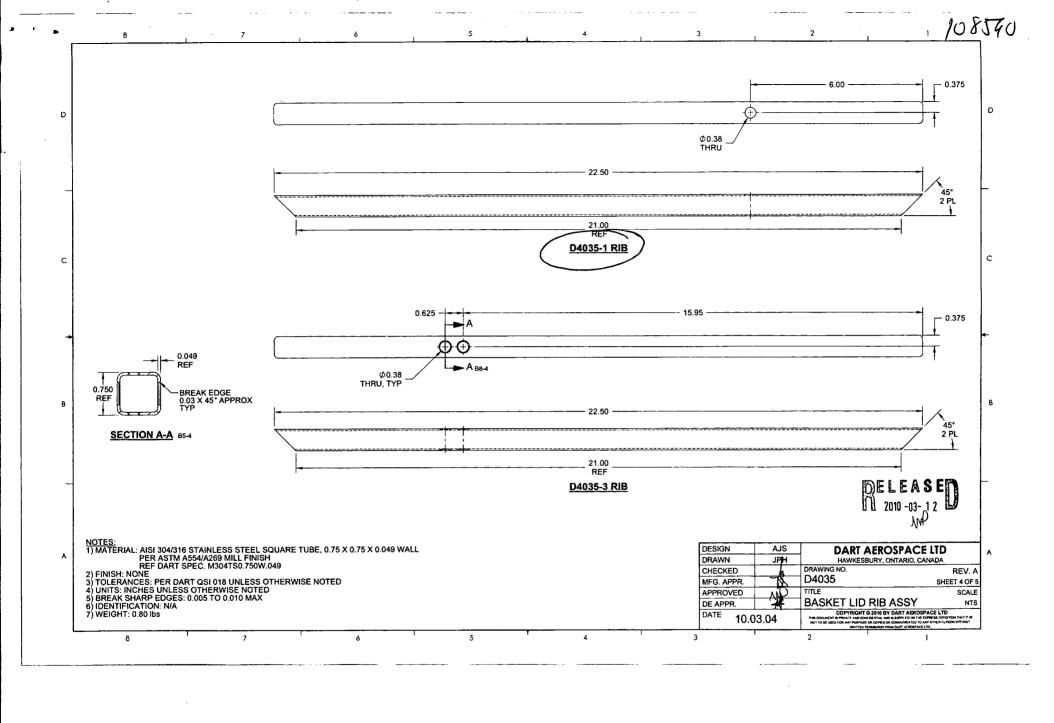
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Turning Sequence

Wave/Twist in Tube

Finish

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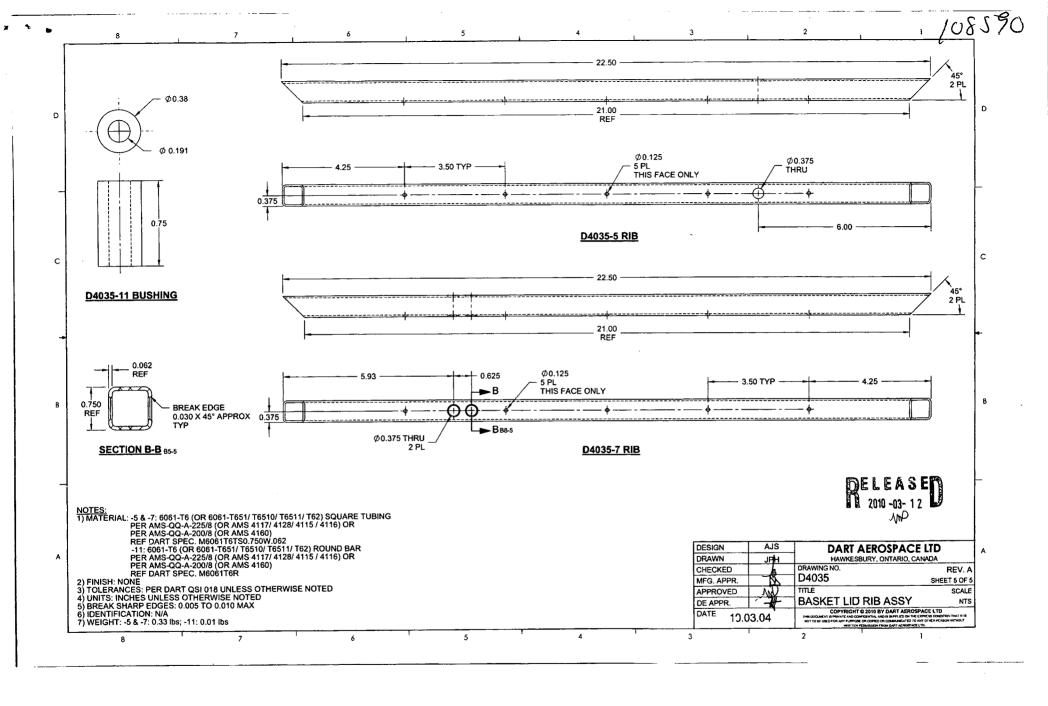
Outside Dimensions

DQA:

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Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



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Part No.						Scrap	1 1	Machining Small Fab			Prod. Eng. Coor.		Quality
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